

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003705**Date Inspected:** 19-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhang Huang/ Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** skin plates and stiffeners**Summary of Items Observed:**

Tower Shop – Bay 1

Caltrans Quality Assurance Inspector George Goulet (QA Inspector) randomly observed ZPMC personnel performing the following: SAW of NSD1-SA10A/K-16A skin plate butt weld under the direction of ZPMC CWI Zhang Huang and ABF QC Xiao Jun Peng; FCAW-G automatic with gantry of stiffener to SSD1- skin E; heat straightening of skin plates and grinding on same. Approximately 50 workers were present in this shop including ZPMC CWI and ABF QC noted above.

Tower Shop – Bay 2

QA Inspector randomly observed ZPMC personnel performing the following: manual FCAW-G of stiffener to skin plate welds on ESD1- skin A which was tilted up to create a flat position for this welding; FCAW and SAW of stiffener butt welds; FCAW-G automatic with gantry and FCAW-G manual of stiffener to ESD1- skin E welds. ZPMC CWI Li Yang and ABF QC Xing Xiao Guang were present as well as approximately 40 ZPMC workers.

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This qualified welder is operating the SAW equipment performing the NSD1-SA10A/K-16A butt weld.



These four welders follow and monitor the FCAW-G weld being installed by the gantry equipment while QC monitors the parameters.

Summary of Conversations:

No significant conversations on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi, 136-6471-0411, who represents the Office of Structural Materials for your project.

Inspected By: Goulet, George

Quality Assurance Inspector

Reviewed By: Carreon, Albert

QA Reviewer